

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-016824**Date Inspected:** 20-Sep-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** N/A**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance(QA) Inspector Mr. Shrikant Utekar was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. The QA Inspector observed and/or found the following:

TRIAL ASSEMBLY YARD

ULTRASONIC TESTING

OBG SEGMENT 10BW-10CW

ABF Request No: 09192010-2

This QA Inspector performed verification Ultrasonic Testing in accordance with ABF/CT Pattern "D" UT Procedure 001 Revision 1. All recordable Indications if found were recorded on a separate data sheet that Caltrans QA generates after performing a joint inspection with ABF ultrasonic testing personnel. The location of the inspection was identified as the bottom panel splice weld between OBG segments 10BW and 10CW. The weld designations were as follows:

OBW10C-003 (OBG 10BW-10CW, BP)

OBG SEGMENT 10BW

ABF Report No: UT-10W-043R1

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## WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

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This QA Inspector performed verification Ultrasonic Testing in accordance with ABF/CT Pattern "D" UT Procedure 001 Revision 1. All recordable Indications if found were recorded on a separate data sheet that Caltrans QA generates after performing a joint inspection with ABF ultrasonic testing personnel. The location of the inspection was identified as the hold back welds between deck panel and edge panel of OBG segment 10BW at intersection of OBG segment 10CW on cross beam side. The weld designations were as follows:

CA074-002 (OBG 10BW, DP to EP, CB side @ 10CW)

### OBG SEGMENT 10CW

ABF Report No: UT-10W-043R1

This QA Inspector performed verification Ultrasonic Testing in accordance with ABF/CT Pattern "D" UT Procedure 001 Revision 1. All recordable Indications if found were recorded on a separate data sheet that Caltrans QA generates after performing a joint inspection with ABF ultrasonic testing personnel. The location of the inspection was identified as the hold back welds between deck panel and edge panel of OBG segment 10CW at intersection of OBG segment 10BW on cross beam side. The weld designations were as follows:

SEG063\*-035 (OBG 10CW, DP to EP, CB side @ 10BW)

### OBG SEGMENT 10BW-10CW

ABF Report No: UT-10W-036R1

This QA Inspector performed verification Ultrasonic Testing in accordance with ABF/CT Pattern "D" UT Procedure 001 Revision 1. All recordable Indications if found were recorded on a separate data sheet that Caltrans QA generates after performing a joint inspection with ABF ultrasonic testing personnel. The location of the inspection was identified as the deck panel splice weld between OBG segments 10BW and 10CW. The weld designations were as follows:

OBW10A-003, 004 (OBG 10BW-10CW, DP)

### MAGNETIC PARTICLE TESTING

### OBG SEGMENT 10BW-10CW

ABF Request No: 09192010-2

This QA Inspector witnessed ABF personal performing Magnetic Particle Testing the bottom panel splice weld between OBG segment 10BW and 10CW. Inspection was carried out on repair areas only. The weld identification numbers were.

OBW10C-003 (OBG 10BW-10CW, BP)

No relevant indications were observed by this QA Inspector on this date.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

### Summary of Conversations:

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## WELDING INSPECTION REPORT

( Continued Page 3 of 3 )

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No significant conversations were reported on this date.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, +(86) 1500 042 2372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Utekar,Shrikant
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Quality Assurance Inspector
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<b>Reviewed By:</b>	Peterson,Art
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QA Reviewer
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